

Work Order ID 86696

86696

Page 1

July-06-12 11:35:35 AM

Item ID: D3209-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 7/06/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date: 12/07/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3209

Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Turn D3209-3 bushing as per Folio FA354 and Dwg D3209

mf / 12/07/12

30

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mf / 12/07/12

30

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

mf 12-7-16

30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location:

8/34

0.00

130

Packaging

Memo

0.00

Packaging

20

12-7-14

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/18

mf
12-07-18

Dart Aerospace Ltd

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Picklist Print

July-06-12 11:35:35 AM

Page 1

Work Order ID: 86696

Parent Item: D3209-3

Parent Item Name: Bushing

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP A04.04.14New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500 303 Round Bar 0.500"		Purchased	No			100	f	261.7260	0.0333	0.4206312			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	261.726	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
121728	74.584	

1.052 mk 12/07/16

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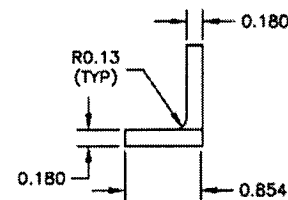
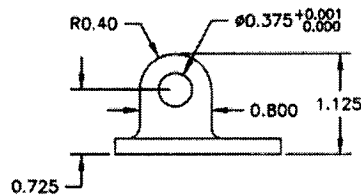
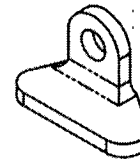
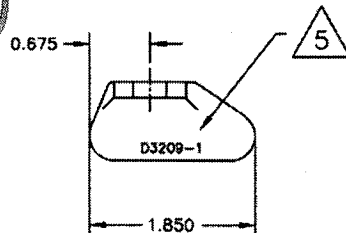
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DART

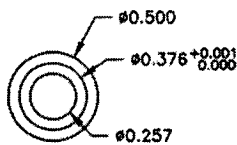
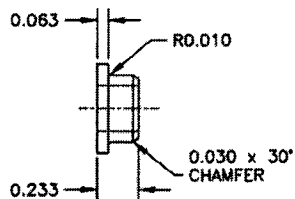
DESIGN <i>HT</i>	DRAWN BY <i>HT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HT</i>	APPROVED <i>HT</i>	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05 *HT*



2

D3209-1 BRACKET



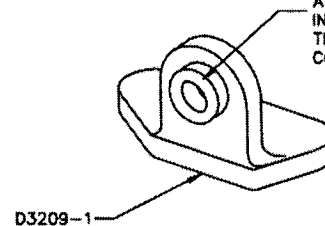
3

D3209-3 BUSHING
SCALE 1:2

4

D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86694*

112075

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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Dart Aerospace Ltd

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